

ABSTRACT OF THE DISCLOSURE

A method of forming a headliner includes overlaying a cover material onto a multi-layer substrate and at least partially separating the cover material from the substrate during the overlaying. The cover material is clamped separately from
5 the substrate. The overlayed cover material and substrate are then transported into a mold. The substrate is unclamped while the cover material remains clamped, and the cover material and substrate are molded together to form the headliner.

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